

Date: Thursday, 8/30/2007 3:51:06 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	STRUT	
Job Number	34359				
Estimate Number	10273				
P.O. Number	N/A		Part Number	D2565101	
This Issue	8/30/2007	S.O. No.	S.O. No.	D2565 REV E	
Prsht Rev.	NC		Project Number	N/A	
First Issue	N/A	Type	SMALL /MED FAB	Drawing Revision	E
Previous Run	33048		Material	N/A	
Written By			Due Date	9/12/2007	
Checked & Approved By	KJ 07.08.31		Qty:	13	
Comment	Est: F 02.04.16 Added dwg Rev.C1 NG		Um:	Each	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 1.7955 f(s)/Unit Total : 17.9550 f(s) 304 RD TUBE .750 X.49W 23.3415 Material :304/316/318-2B Seamless Tubing, 3/4" O.D. x 0.049" wall per Dwg (M304TR0750W049) Batch M105354	FF 07-09-13 13
2.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Punch as per Dwg D2565 using DT 8313	FF 07-09-13 13
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill hole open to .316 Ø as per Dwg D2565 (one end only) Deburr and polish	SAD 07/09/13 (B)
4.0	QC5	INSPECT WORK TO CURRENT STEP	 Count
		Comment: INSPECT WORK TO CURRENT STEP	S 07/09/14 (X B)
5.0	POWDER COATING	POWDER COATING	 PFC →
		Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3	ES 07-09-17 (B)
			M-F 07/09/18 (2x)

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: D Date: 07/09/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/19	# S.O	2 parts were found after powder coat with the number of the part. Showing through the powdercoat.	<u>QSI 09/12</u>	Remove <del>the</del> Powder coat and Buff out numbers wash with wash nwide * inspect QC #5	<u>07/09/19</u> <u>07/09/19</u>	<u>C</u>	<u>07/09/19</u>	<u>SP</u> <u>07/09/19</u>
↓	↓	↓	↓	Re Powder coat as per OSI 005.	<u>M/F</u> <u>07/09/19</u>	<u>C</u>	<u>07/09/19</u>	↓

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 34359

Part Number: D2565101

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Ep 07/09/18

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 259

Ep 07/09/18 (3)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Ep 07/09/18

Job Completion



Ep 07/09/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

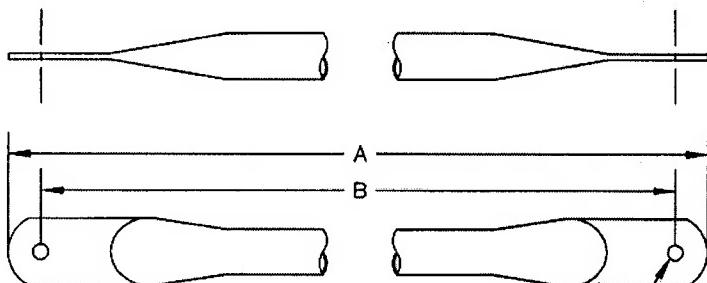
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**COPY ISSUED  
TO

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. E D2565 SHEET 1 OF 1	
DATE 04.05.05		TITLE	SCALE 1:3	
A	96.05.03	NEW ISSUE		
B	97.03.15	CORRECT D2565-111 DIM. A		
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)		
D	02.06.05	ADD -3XX PARTS; ADD FINISH		
E	04.05.05	ADD D2565-401-411; RMV ANGLE D		

**RELEASED**  
04.05.05

DIA 0.257 TO BE PUNCHED  
 "C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

#### GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
 (REF. DART SPEC. M304TR0.750W0.049)  
 ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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 ENGINEERING

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WITHOUT NOTICE

WORK ORDER

NO. 34359

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